

cut 20.73

Work Order ID 140880

140880

January 21, 2016 1:48:39 PM

Item ID: D2562-001 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Strut 19.68"
Start Date: 1/21/2016 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 2/5/2016 Req'd Qty: 6.00 *6* Customer:

Reference:

Approvals: Process Plan: SH Date: 20160121 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2562	Rev D								
100	NC BRAKE	0.00				6	FF	FEB 01 2016	
100									
Brake NC	Memo	0.03							
Brake NC	Punch to length as per Dwg D2562								
110	Small Fab	0.00				6	FF	FEB 01 2016	
110									
Small Fab	Memo	0.02							
Small Fab	1- Bend end as per Dwg D2562 Angle "D"2-Debur								
120	QC5- Inspect part completeness to step on W/O	0.00				6			
120									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89

FEB 01 2016

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QS005 4.3-Steel <i>N130724.</i> Memo START TIME: <i>7:05</i> OVEN TEMPERATURE: <i>465</i> FINISH TIME: <i>8:25</i>	0.00 0.00				<i>6</i>	<i>0</i>	<i>16-02-4</i>	<i>338</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>(6)</i>			DAS 38 9-89 FEB 04 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>51353</i> Memo	0.00 0.00				<i>6</i>	DAS 8 9-89		FEB 04 2016

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.01							
Quality Control									

MC5 FEB 04 2016

MC5 FEB 04 2016

.DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	OTHER : _____							
Misidentified	☐	Past Due								

Picklist Print

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Parent Item: D2562-001

D2562-001

Parent Item Name: Strut 19.68"

Start Date: 1/21/2016

Required Date: 2/5/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP F02.04.15Added dwg Rev.B1 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	87.6296	1.7067	10.77916			
M304TR0 500W 035									**	FF		FEB 01 2016	
304 RD Tube .500 x .035W													

Location

Loc Qty

Loc Code

GA

40

m133509

40

GA002

47.6295764

m128495

4.14737

m132775

2

m132872

8.6822064

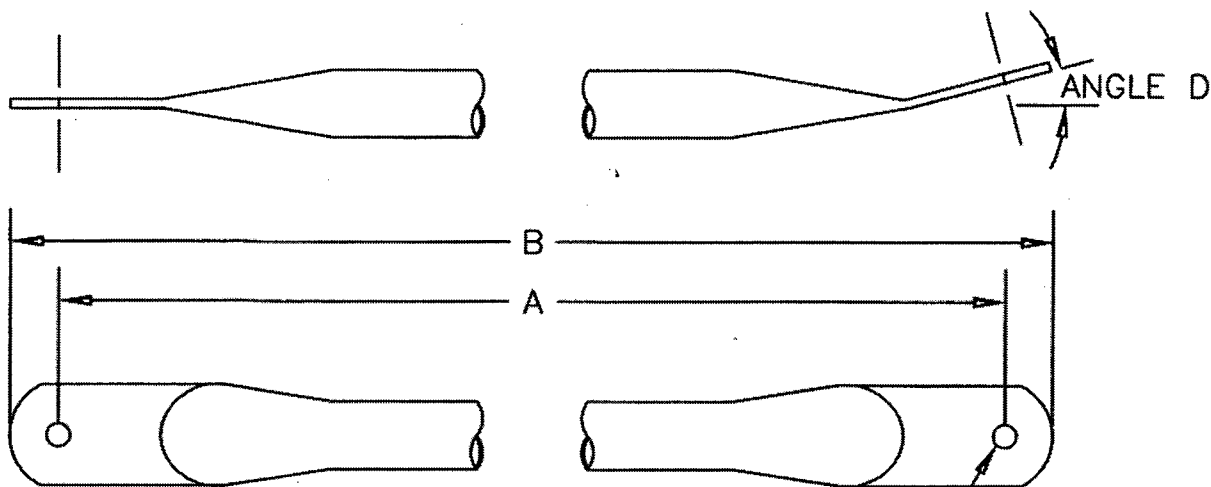
m133611

32.8

10.779



DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.18	DRAWING NO.	D2562	REV. D
		TITLE	STRUT	SHEET 1 OF 1
A	96.05.01	NEW ISSUE		SCALE
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)		1:2
C	02.06.05	ADD -005; ADD FINISH		
D	05.05.18	ADD -007/-011/-013; UPDATE -005		



"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

20160121

5A

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